

60130-1220
01MMRA0210-CIP**AMENDMENTS TO THE CLAIMS:**

Please amend the claims as follows. This listing of claims will replace all prior listings.

1. (CURRENTLY AMENDED) A method of forming an axle assembly comprising the steps of:
 - a) providing a cylindrical hollow member having an end portion;
 - b) forming the end portion to provide a first generally circular end,
 - ~~c) forming a section of the cylindrical hollow member into a multi-wall thickness section; and~~
 - c) d) welding a preformed kingpin boss to the generally circular end.
2. (ORIGINAL) The method according to claim 1, further including the step of bending the hollow portion to a desired shape subsequent to step c).
3. (CURRENTLY AMENDED) The method according to claim 1, further including the step of inserting a formable bulkhead into a cavity of the hollow member prior to step b).
4. (CURRENTLY AMENDED) The method according to claim 1, wherein said step b) includes ~~forming swaging the end portion multi-wall thickness section~~ into a generally frustroconical shape.
5. (CURRENTLY AMENDED) The method according to claim 1, further including the steps of ~~forming swaging the hollow member~~ into a generally polygonal cross-section after said step a).

60130-1220
01MMRA0210-CIP

6. (CURRENTLY AMENDED) The method according to claim 1, further including the steps of:

- a1) inserting a bulkhead into a cavity of the hollow member prior to said step b); and
- a2) forming simultaneously swaging the hollow member and bulkhead into a generally polygonal cross-section after said step a1) and prior said step b).

7. (CURRENTLY AMENDED) A method of forming an axle assembly comprising the steps of:

- a) providing a cylindrical hollow member having an end portion;
- b) forming the end portion to provide into a kingpin boss; and
- c) bending the hollow member to a desired shape

8. (ORIGINAL) The method according to claim 7, further including the steps of forming the hollow member into a generally polygonal cross-section.

9. (CURRENTLY AMENDED) The method according to claim 7, further including the steps of:

- a1) inserting a bulkhead into a cavity of the hollow member prior to said step b); and
- a2) simultaneously forming the hollow member and the bulkhead into a generally polygonal cross-section after said step a1) and prior said step b).

10. (ORIGINAL) The method according to claim 7, further including the step of forming a multi-wall thickness length in the hollow member.

11. (NEW) The method according to claim 1, further including the steps of:

- a1) inserting a metallic bulkhead into a cavity of the hollow member prior to said step b) such that a portion of the cavity is solid; and
- a2) simultaneously swaging the hollow member and the metallic bulkhead into a generally polygonal cross-section prior said step b).

60130-1220
01MMRA0210-CIP

12. (NEW) The method according to claim 7, wherein said step b) comprises swaging the cylindrical hollow member into a generally polygonal cross-section.
13. (NEW) The method according to claim 7, wherein said step b) further comprises the step of:
- b1) swaging the end portion to form the kingpin boss.
14. (NEW) The method according to claim 13, wherein said step b) further comprises the step of:
- b2) inserting a metallic bulkhead into the end portion such that the end portion is solid;
- and
- b3) simultaneously swaging the hollow member and the metallic bulkhead to provide the kingpin boss.
15. (NEW) A method of forming an axle assembly comprising the steps of:
- a) providing a cylindrical hollow member having an end portion;
 - b) swaging the cylindrical hollow member to provide a non-cylindrical section; and
 - c) bending the non-cylindrical section to a desired shape.
16. (NEW) The method according to claim 15, wherein said step b) comprises swaging a multi-wall thickness section of the cylindrical hollow member.
17. (NEW) The method according to claim 15, further comprising the steps of:
- d) inserting a metallic bulkhead into the end portion such that the end portion is solid;
- and
- e) simultaneously swaging the hollow member and the metallic bulkhead to provide the kingpin boss.

60130-1220
01MMRA0210-CIP

18. (NEW) The method according to claim 15, further comprising the steps of:
- d) inserting a metallic bulkhead into the hollow member prior to said step b); and
 - e) simultaneously swaging the hollow member and the metallic bulkhead into a non-cylindrical cross-section.